

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SCUFF PLATE	
Job Number	: 33110			
Estimate Number	: 10825			
P.O. Number	: N/A	Part Number	: D206555004	
This Issue	: 6/25/2007	S.O. No.	: N/A	
Prsht Rev.	: NC	Drawing Number	: D206-555 REV C	
First Issue	: N/A	Project Number	: N/A	
Previous Run	: 30264	Drawing Revision	: C	
	Type : SMALL /MED FAB	Material	: N/A	
Written By	: <u>[Signature]</u>	Due Date	: 7/10/2007	Qty: 10 Um: Each
Checked & Approved By	: <u>[Signature]</u>			
Comment	: Est Rev: E 99.06.29 Returned to Electro Polish DM			
	: Est Rev: F Now On Waterjet 07-01-22 JLM			

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Type Labels as per PPP D206-555-004

2.0 M304S25GA 304/316 .020" Sheet

Comment: Qty.: 0.4610 sf(s)/Unit Total : 4.6100 sf(s)

304/316 .020" Sheet

Batch:

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

Comment: FLOW WATER JET

1-Cut as per Dwg D206-555

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK

Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/14/13	6							

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:10:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 33110

Part Number: D206555004

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form parts on hydraulic press as per Dwg. D206-555 using DT 8316-4

2-Finish form on bench forming Jig DT 8317-4

FF 07-11-14
SB 07/11/13

(10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JA 11/14 (10)

8.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: 5646

Possible supplier: TQF Technologies

CO 7/11/14 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

LC 7/14/22

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6 A 11/22 (10)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

MA

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 A 11/22 (10)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AS 07/11/22 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 01/11/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:10:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 33110

Part Number: D206555004

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10
R 08/11/23

Job Completion



U 08.11.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

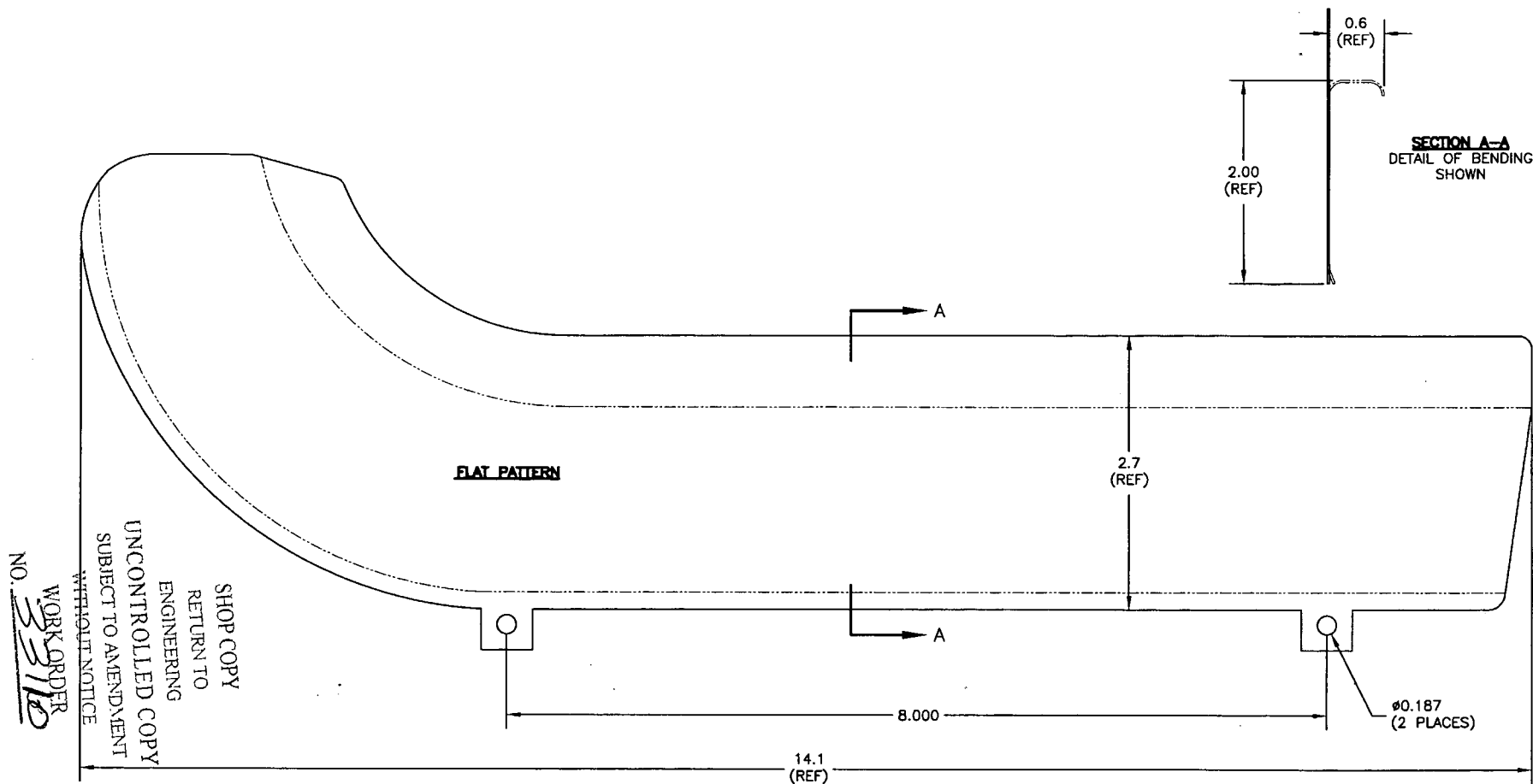
DESIGN JB	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *33110*

RELEASED*06.09.19* *[Signature]***Copyright © 1989 by DART AEROSPACE LTD**

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D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)
D206-555-002 (BEND OPPOSITE)

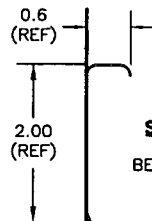
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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06.09.19

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CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 2 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	



SECTION C-C
DETAIL OF
BENDING SHOWN

DETAIL B
SCALE 1:1

REFER TO DETAIL B
FOR 1:1 SCALE

16.000 (REF)

2.7
(REF)

FLAT PATTERN

8.000

19.0
(REF)

8.000

Ø0.187
(3 PLACES)

RELEASED

06.09.19-#

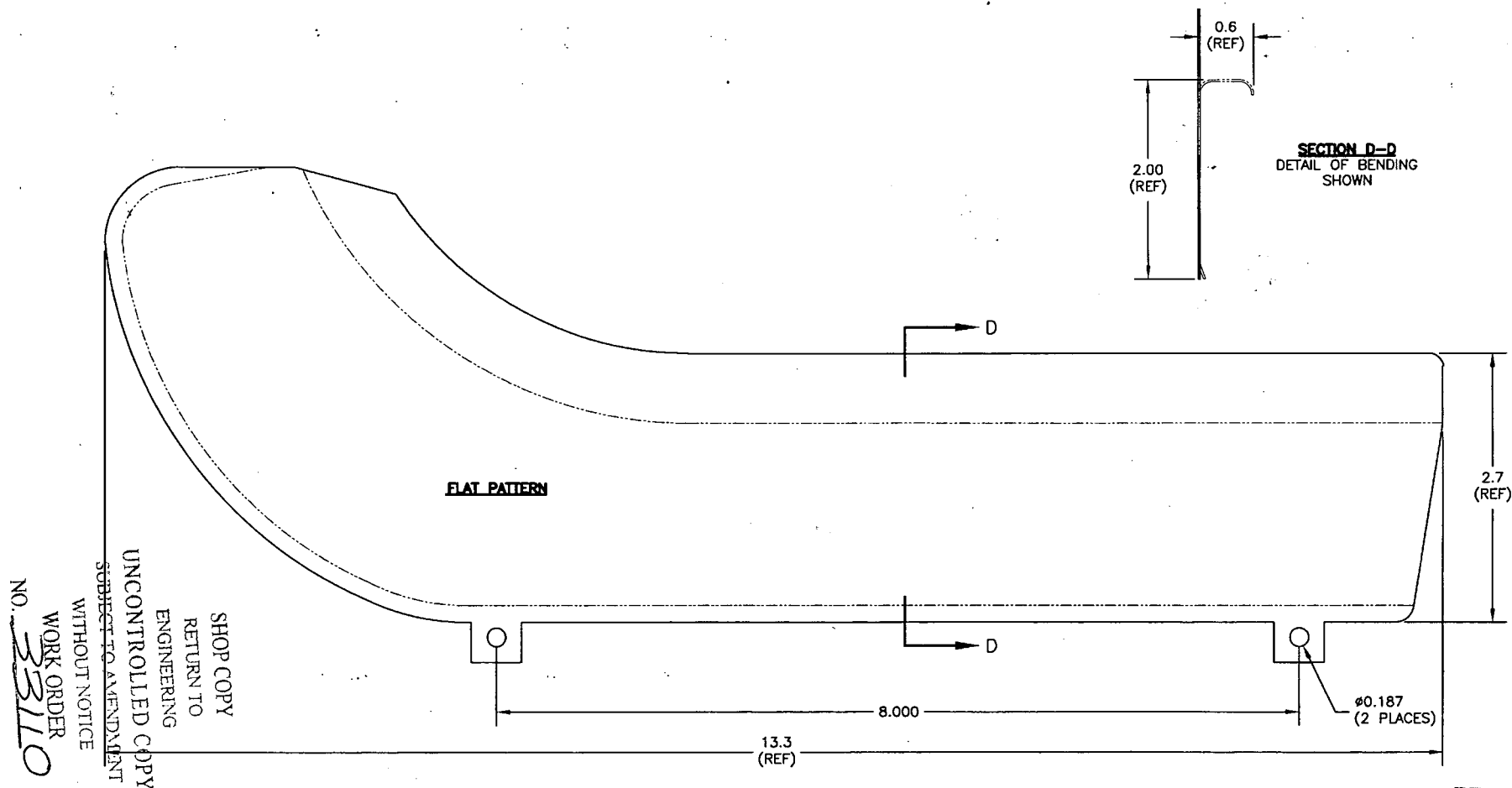
D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)
D206-555-004 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED PH	APPROVED BY [Signature]	DRAWING NO. D206-555	SHEET 3 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE	2:3

NO. 33110
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 RETURN TO
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 ENGINEERING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33110

D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)
D206-555-006 (BEND OPPOSITE)

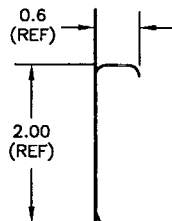
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T5
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

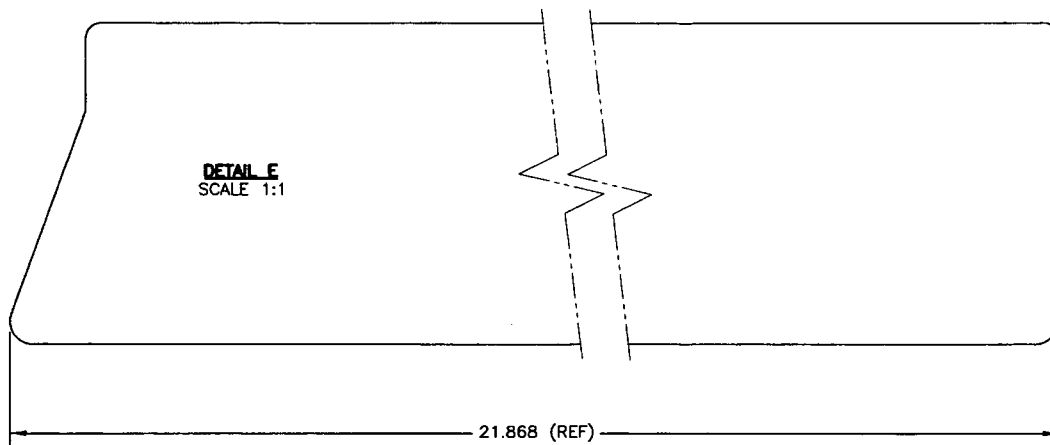
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06.09.19

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CHECKED PH	APPROVED PH	DRAWING NO. D206-555	REV. C SHEET 4 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES		SCALE 1:1

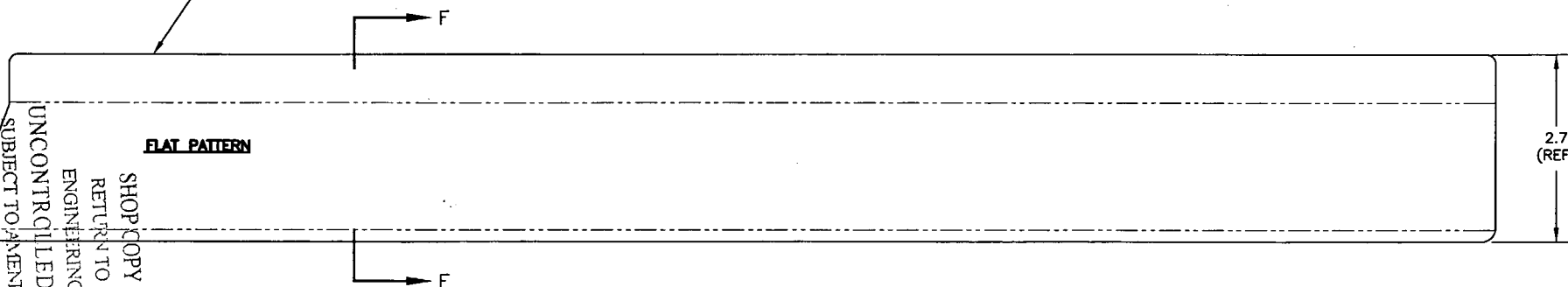


SECTION F-F
DETAIL OF
BENDING SHOWN



DETAIL E
SCALE 1:1

REFER TO DETAIL E
FOR 1:1 SCALE



FLAT PATTERN

2.7
(REF)

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WORK ORDER
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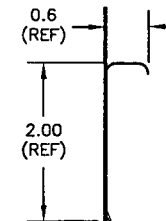
06.09.19 #

D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED H	DRAWING NO. D206-555	SHEET 5 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



SECTION H-H
DETAIL OF
BENDING SHOWN

REFER TO DETAIL G
FOR 1:1 SCALE

DETAIL G
SCALE 1:1

16.000 (REF)

H

18.9
(REF)

FLAT PATTERN

8.000

H

8.000

Ø0.187 (TYP 3 PLACES)

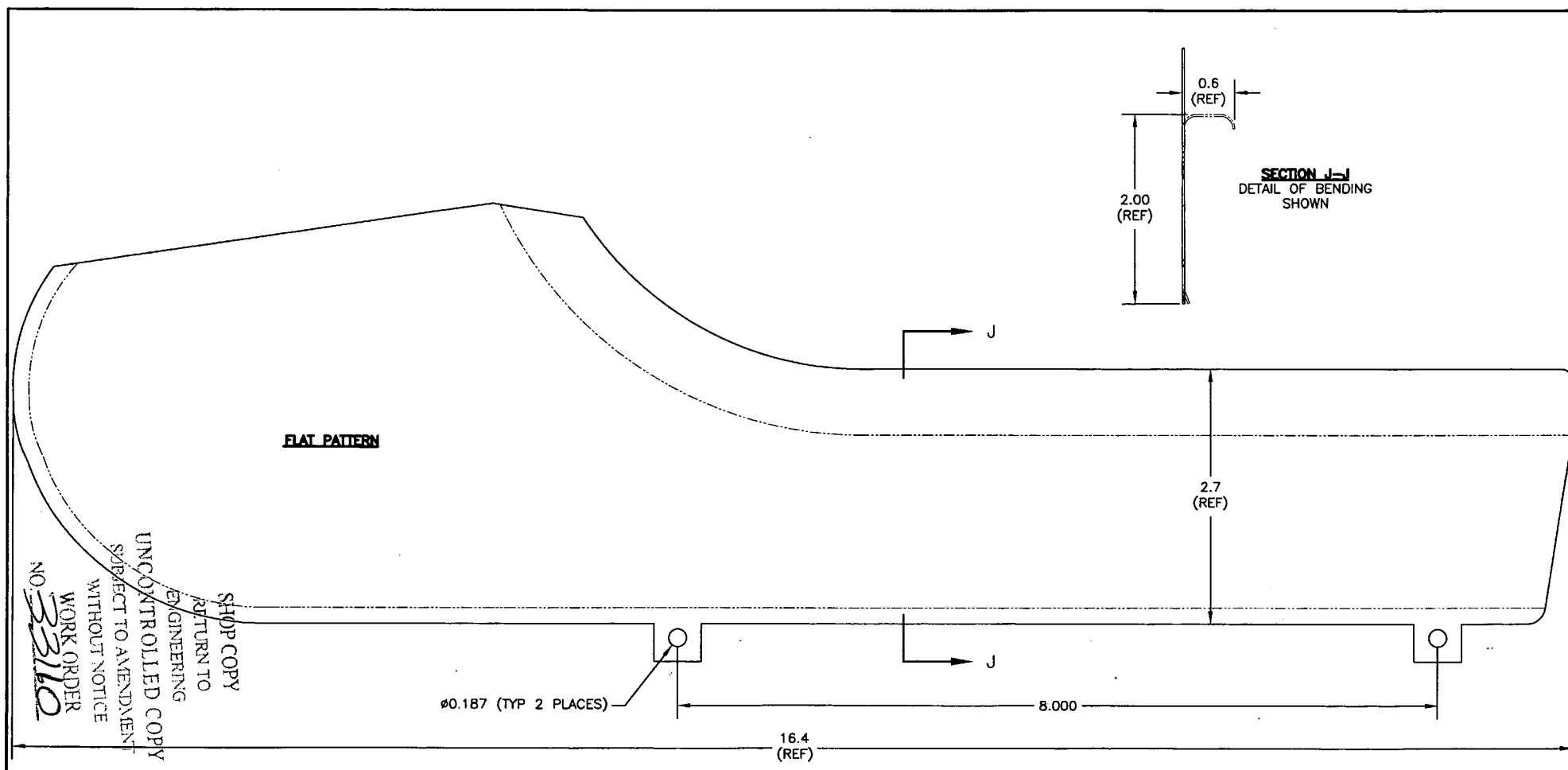
NO. 3310
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
IN CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY <i>[Signature]</i>	DART DART AEROSPACE LTD HUNTSBURY, ONTARIO, CANADA	REV. C
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 2:3



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)

D206-555-012 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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06-09-01

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	SHEET 7 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 1:1

Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: November 21, 2007

1270 Aberdeen St

Hawkesbury, Ontario

No. de certificat
Certification No.

K6A 1K7

tel.: (613) 632-5200

fax: (613) 632-1053

C121763

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
133024		NO. DE COM./P.O.# 5046	ELECTROPOLISH PER ASTM B912 REV.02
	4	D206-555-003 REF#B31604	
	10	D206-555-003 REF#B33109	
	10	D206-555-004 B30264 REF#B33110	

[Signature]
9/11/22

Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et spécifications et sont en accord avec les exigences ci-inclus.

We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.

Signé pour et au nom de TQF Technologies Inc.
Signed for and on behalf of TQF Technologies Inc.

[Signature]

G. Persaud / G. McPhee

Total Quality Finishing